

Date: Wednesday, 27/08/2008 3:15:35 PM
 User: Julie Lecocq

Process Sheet

SPLIT-2

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 41648 -2
 Estimate Number : 12576
 P.O. Number :
 This Issue : 27/08/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 27/08/2008 Type : LARGE FAB ASSY
 Previous Run : 41245

Drawing Name : STEP WELDMENT

Part Number : D3562041
 Drawing Number : D3562 REV E
 Project Number : N/A
 Drawing Revision : E
 Material :
 Due Date : 08/09/2008

Qty: (2) Um: Each

Written By :
 Checked & Approved By : JLD 08.08.26

Comment : Est Rev:A New Issue 06-11-09 JLM
 Est rev B ECN 987 07.10.09 EC verified by: DD
 Est Rev:C ECN1048 07-12-18 DD verified by:ec
 Est Rev:D 08-07-28 add chemical conversion coat DD
 verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Qty Part # Description Batch:
 1 D2622-120C Extrusion 40937

Check Material for any Dents or Defects

SAD 08/08/28 (4)

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

SAD 08/08/28 (4)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

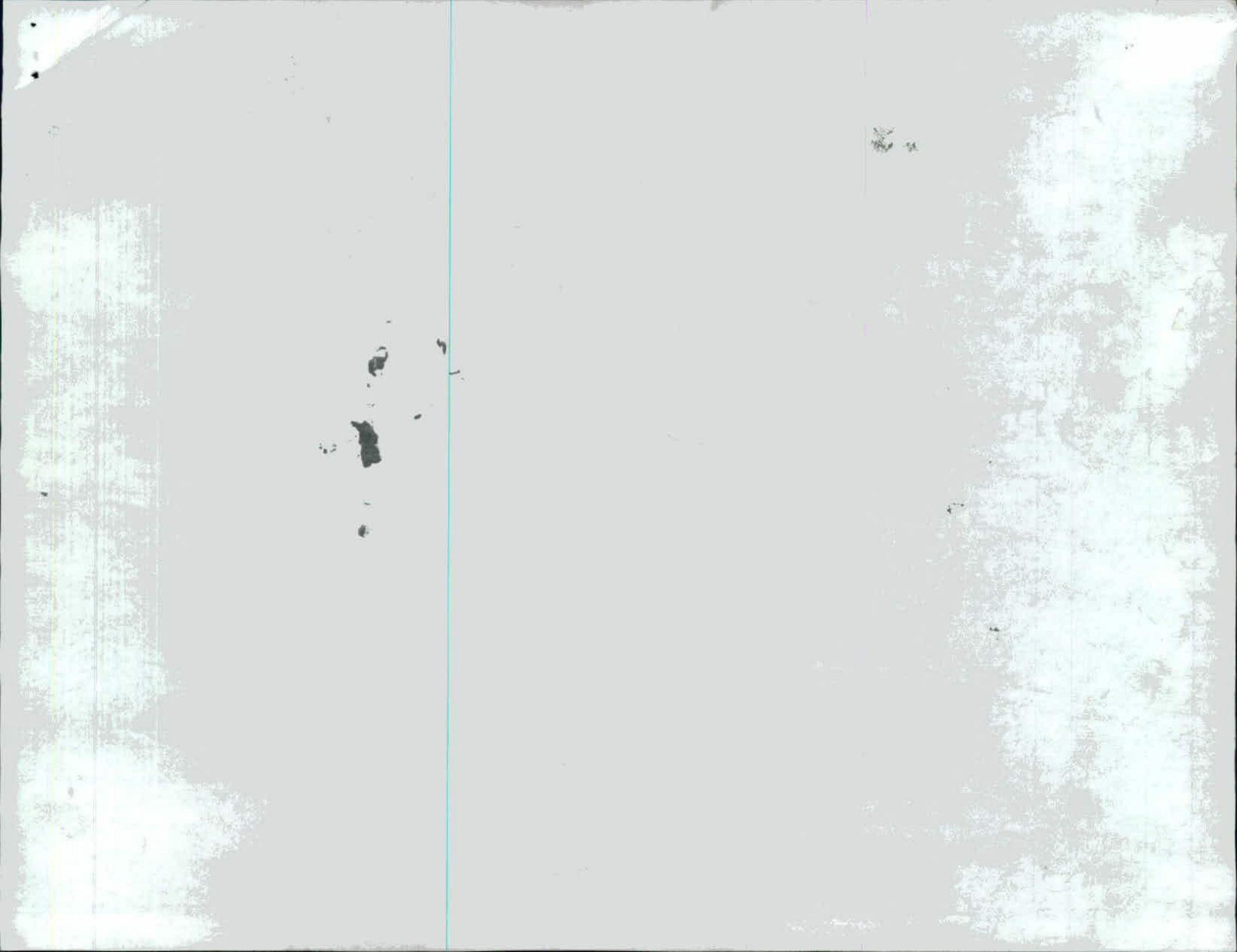
SAD 08/08/28 (4)

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

SAD 08/08/28 (4)



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 41648

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



QA



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-28

(X4)

6.0

D3560041

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

ARM WELDMENT

Batch:

B40299

B40299

B40299

B40299

3X

SP 08.12.02

7.0

D3560043

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

ARM WELDMENT

Batch:

B41068

B40300

SP 08.12.02

(2X)

8.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total: 128.0000 Each(s)

Blind Rivet

batch:

B108990

X

SPD 08-12-02

SP 08.12

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Transfer drill Rivet holes as per dwg D3562.

2-Touch-up rivet holes with alodine as per dwg d3562.

3-Rivet legs using Magnabond as per dwg D3562.

*****Ensure to wipe off any excess magnabond *****

A/R Magnabond 6398

Batch:

M109900

M108966

SPD 08-12-08

SP 08.12.8

SP 08.12

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.12.08 (2X)



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 41648

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2734

Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2734

End Cap

B39179

SP 08.12.08

(1X)

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D35628 QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod

M104855

08-12-08 (2X)

(2X)

2-Grind end cap welds flush as per Dwg D3562

SAD

SP 08.12.08

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PC 0812-08

BE 08-12-08

(2X)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/08

(2X) (LH)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

+ pressure wash

HL

08-12-09

(2X) (LH)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:15
OF
320
9:45

M-L

08/12/09

(2X) (LH)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 41648

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M109219

JU 08-12-09

X2

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/12/09 42

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

G-A

08/12/12 2

20.0

QC21

FINAL INSPECTION/W/O RELEASE



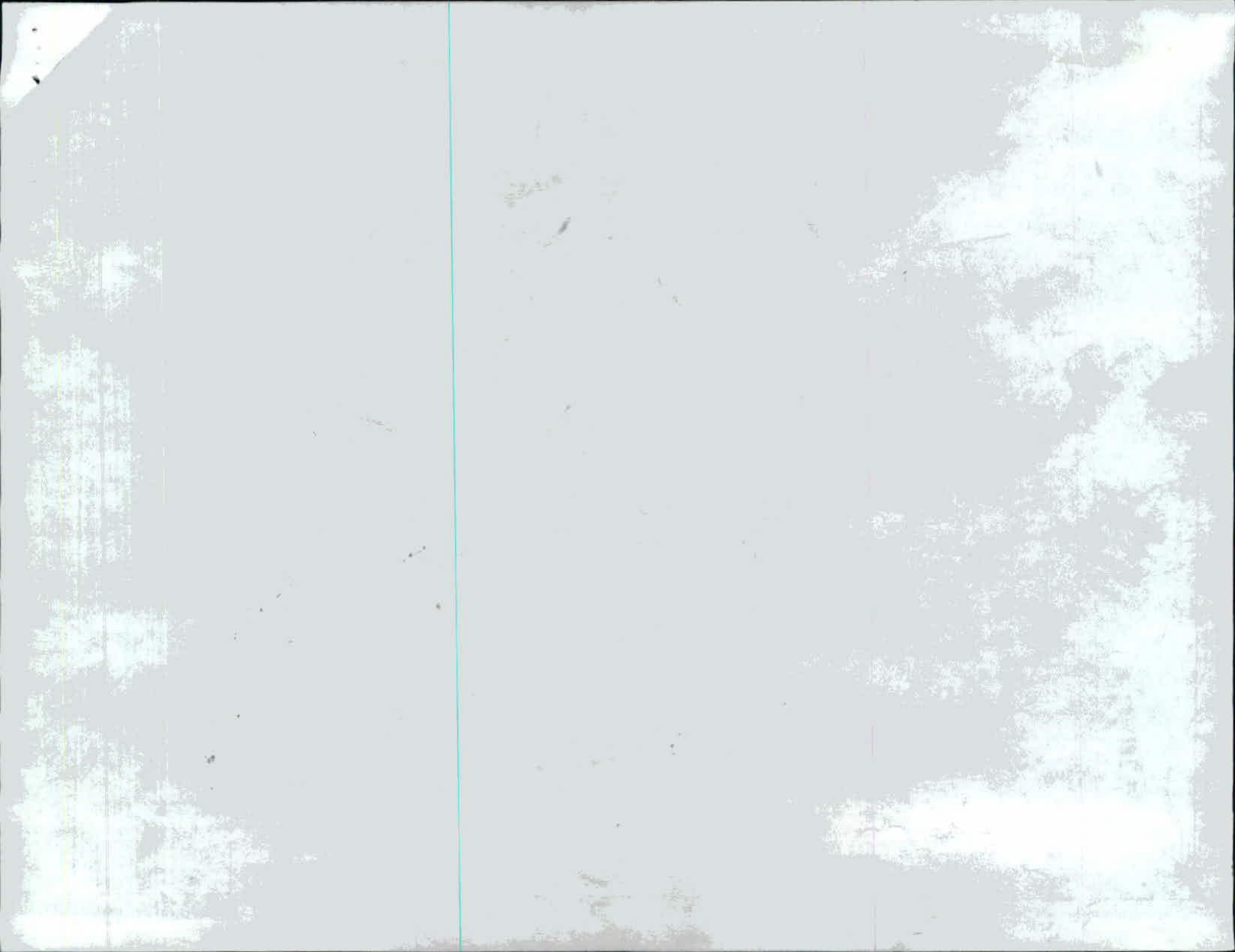
08/12/12 12

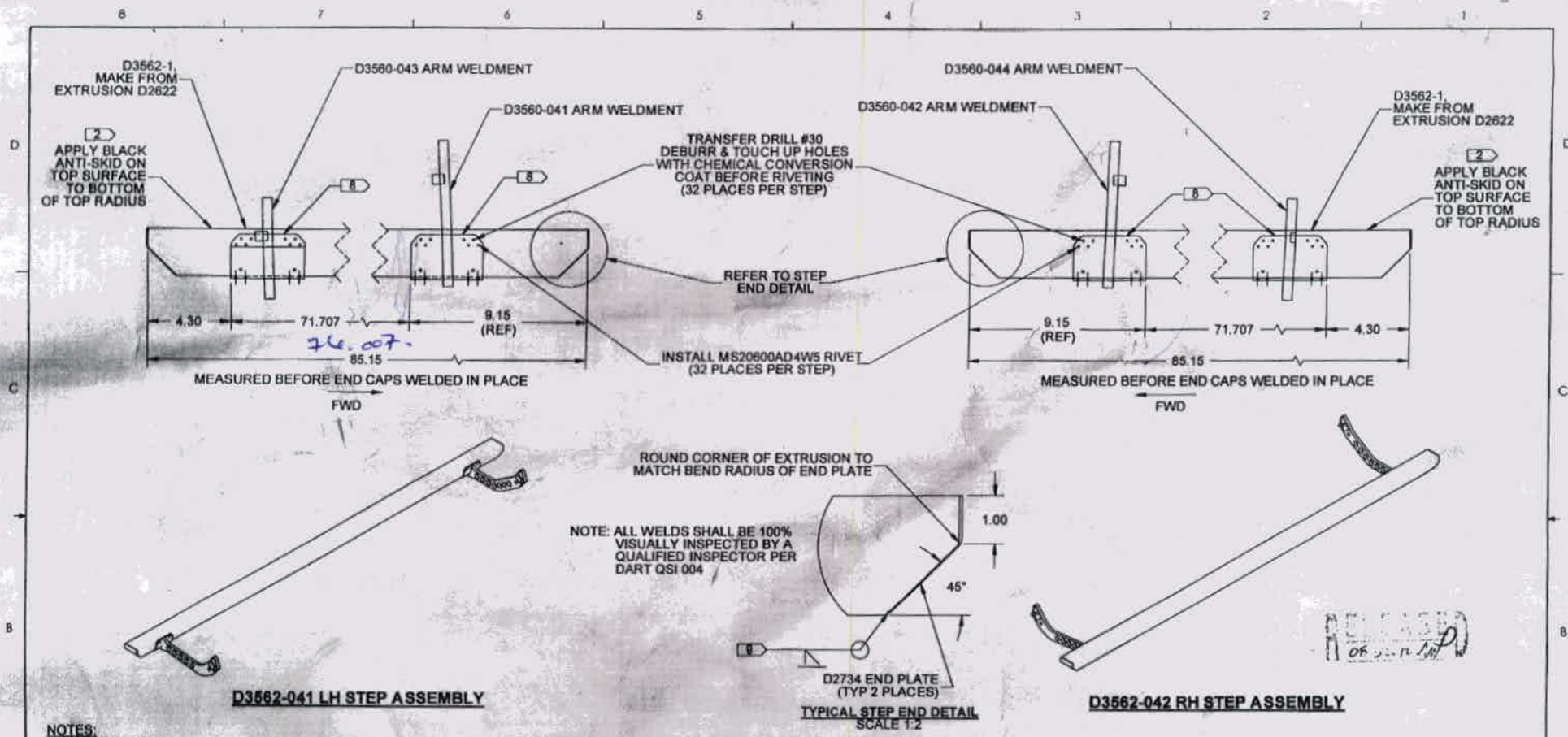
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08.12.12





NOTES:

- 1) MATERIAL: N/A
- 2) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDEXT (4.3.5.6) OR BLACK SANDEXT (4.3.5.7) OR GREEN SANDEXT (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.79 lbs
- 8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 9) WEIGHING PER DART QSI 004

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3562-041	LH STEP ASSEMBLY
	X	D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE, REDRAWN IN SOLIDWORKS	DC	07.11.18
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.05.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.28
REV.	DESCRIPTION	BY	DATE
DESIGN	g		
DRAWN	W		
CHECKED	LE		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.01.11		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA
 DRAWING NO. **D3562**
 TITLE **STEP ASSEMBLY**
 REV. E
 SHEET 1 OF 1
 SCALE 1:5
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